

phone 510 235 2350

email ken@tomassporttuning

web www.tomassporttuning.com

Tomas Sport Tuning assumes no responsibility for adhering to factory warranty specifications. All aftermarket modifications performed to the vehicle by the owner are his/her sole responsibility. All aftermarket parts are for off road use only. This Stressbrace must not be used as a seat belt harness bar or as a structural member for any additional purpose.

List of parts:

- Black anodized aluminum Stressbrace
- Four (4) nutserts
- Four (4) M8 black oxide hex head fasteners
- Installation M8 bolt, washer, and nut

List of required tools:

- T-30 Torx driver
- 2 – 13mm combination wrenches
- Center punch
- Metal scribe
- 5mm Allen wrench (**T handle suggested**)
- 1/8" Drill bit
- 1/4" Drill bit
- 1/2" Drill bit
- Electric drill (that can accommodate a 1/2" bit or use reduced shank bit)
- Standard flat head screw driver
- Hammer

Optional tools:

- Vacuum cleaner
- Rat tail file
- Bungee cord



Thank you for purchasing the Tomas Sport Tuning Stressbrace. For a successful installation ***we strongly recommend patience*** and reading the instructions thorough□ the installation process and once again.....***be patient.***

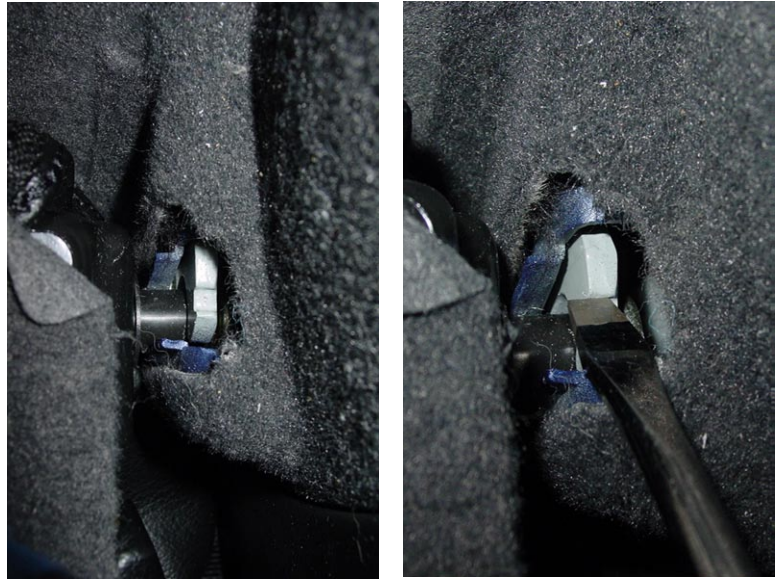
Step 1 — Prepare the rear seat/hatch area

- Use loop at front of rear seat bottoms to pull them forward into the vertical position.
- Remove headrests
- Fold rear seats completely flat
- Remove the carpet in the hatch area



Step 2 — Unhooking rear seats back

- Unclip seat bottoms from their retainers.
- At outer side of seat back, use a flathead screwdriver to pry open clasp.



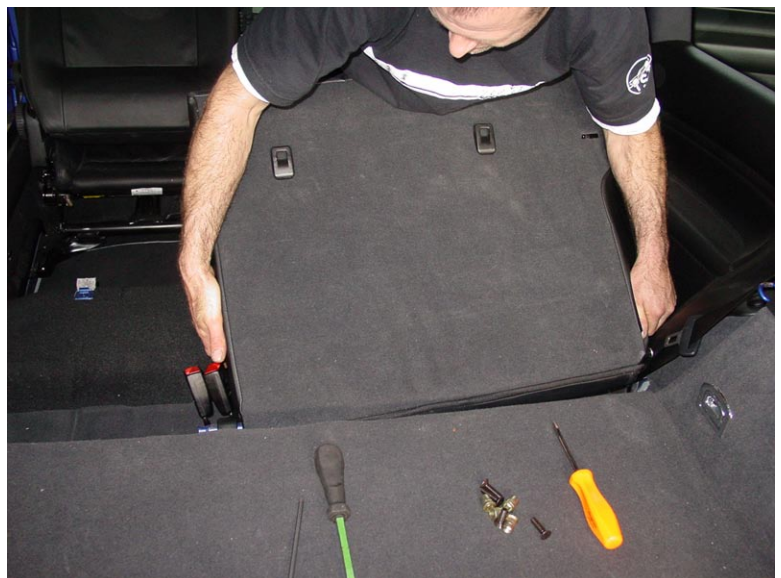
Step 3 — Remove the small rear seat back

- Once the clasp is pryed open from the hinge, lift seat from right side.
- After the pin clears the clasp, slide seat back to the right as you lift up. This will disengage seat from left side pin. It takes some gentle persuasion, so just work the seat back away from the center of the car.



Step 4 — Remove the large rear seat back

- At left side of seat back, use a flathead screwdriver to pry open clasp. (same as step 2).
- Once the clasp is pryed open from the hinge, lift seat from left side.
- After the pin clears the clasp, slide seat to the left as you lift up. This will disengage seat from right side pin. Follow instructions in step 2.



Step 5 — Unhook middle seatbelt from retainer

- Middle seatbelt is hooked into a retaining clip.
- Release lever and remove seatbelt ring from hook.

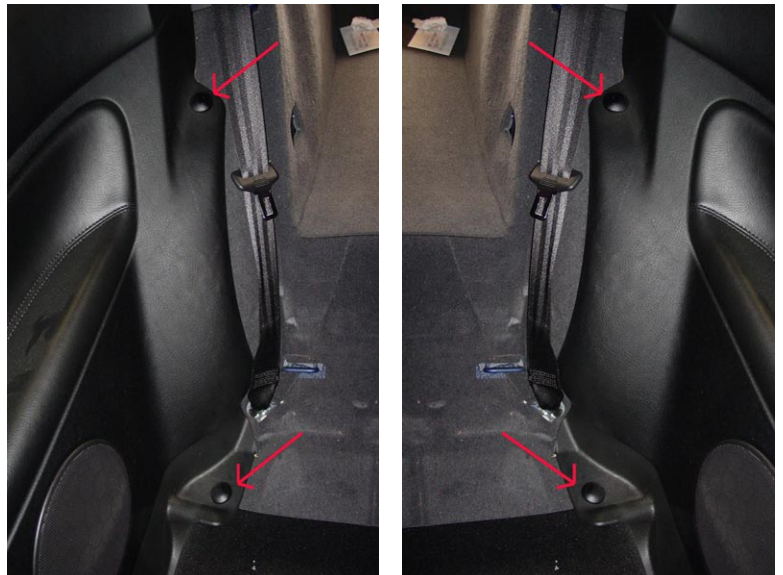


Step 6 — Remove cargo net anchors

- Use T-30 Torx driver to remove the two cargo net anchors closest to the front of the car.



Step 7 — Locate and remove the interior trim dome fasteners



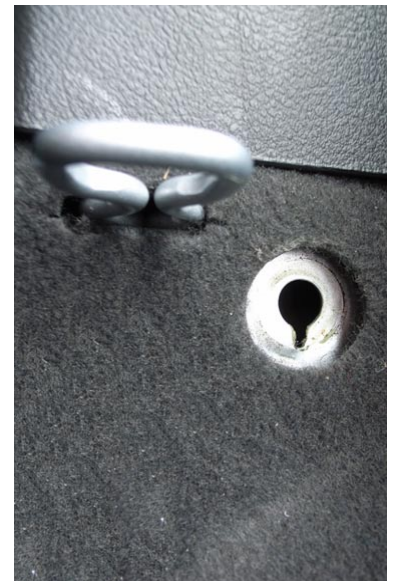
Step 8 — Locate and remove the interior trim dome fasteners

- Unscrew two dome fasteners on each side (four total).



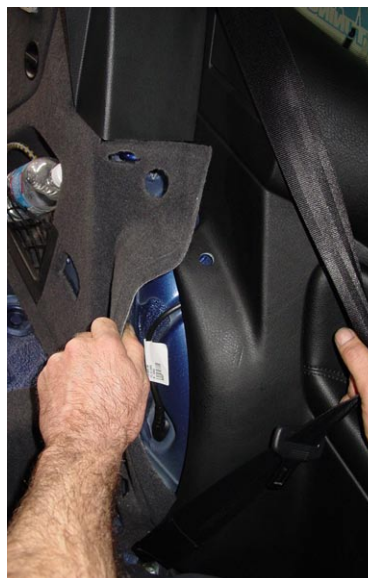
Step 9 — Locate and remove the rubber seat bumpers

- Unscrew the rubber bumpers on each side (two total).



Step 10 — Peel back carpet

- Pull away from rear interior body panels.
- Carefully lift over rear seat latch.
- Once free use bungee cord to keep carpet away from Stressbrace attachment area.
- Repeat on other side.



Step 11 — Test fit the Stressbrace

- Measure equal spaces from top fastener holes to slot for rear seat latch.
- **For R32:** Align Stressbrace even with top of hatch carpet. **Note: This step is critical for proper aesthetic placement.** See step 19 and photographs on page 8.
- **For MkIV:** Hatch floor is lower therefore DO NOT align Stressbrace with hatch floor. Use similar top position as shown in photograph at right.
- **Verify that position is not directly on factory spot welds. Verify that Stress brace is sitting flat at all four corners.** Each car is slightly different so double check your positioning.
- Use metal scribe to mark location of all fastener holes once proper location is set.



Step 12 — Centerpunch scribed areas

- Using centerpunch mark centers of each scribed area.
- Repeat at all four locations.



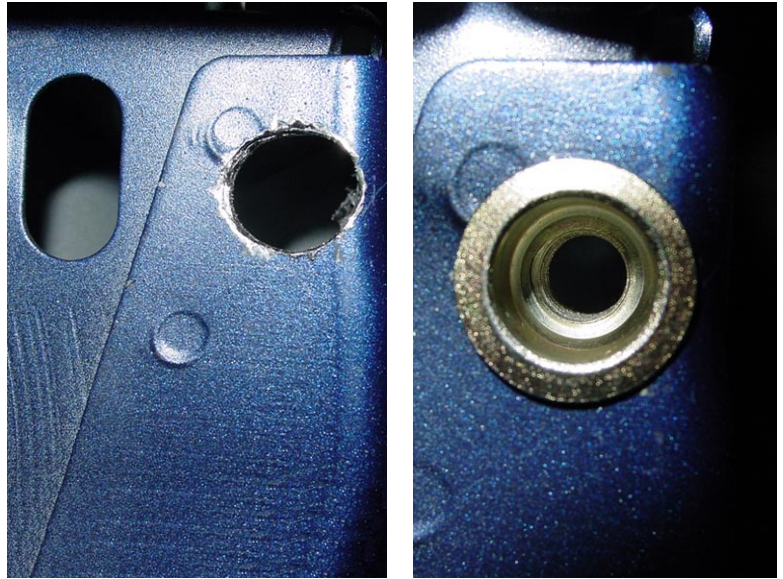
Step 13 — Drill pilot hole

- Using 1/8" bit, drill pilot hole
- Repeat at all four centerpunched locations.



Step 14 — Drill hole for nutserts

- Using 1/2" bit drill hole at all four pilot hole locations. Be careful to drill perpendicular to surface.
- If required use rat tail file to clean hole of sheet metal behind top surface.
- **Note: Do not enlarge hole. Only use for cleaning debris behind top layer. This is critical for proper nutsert fitment.**
- Repeat at all four locations.



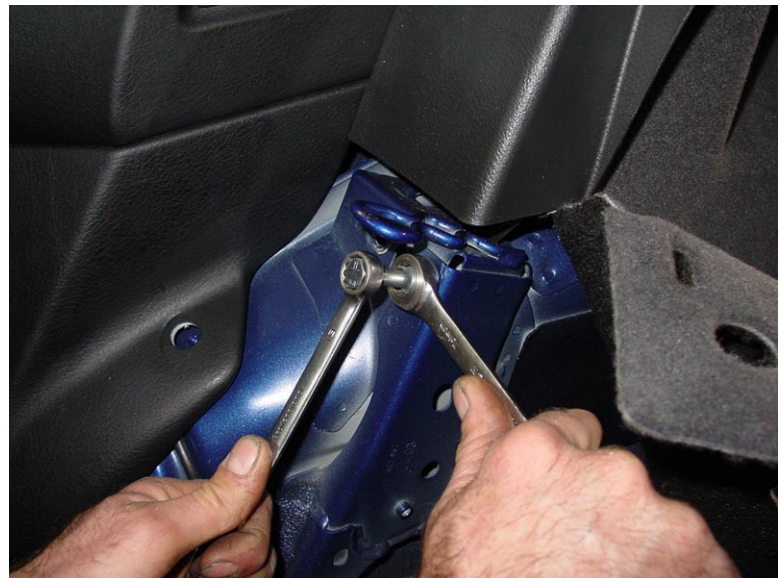
Step 15 — Place installation bolt into nutsert

- Assemble installation bolt in this order: nut, washer, and then nutsert (as shown at right).
- Thread bolt into nutsert.
- Tighten nut firmly into washer.



Step 16 — Set Nutserts

- Using two 13mm combination wrenches, set nutserts to clamp onto sheet metal. Apply uniform pressure and tighten inner wrench on nut. Use outer wrench to hold bolt and stabilize your assembly.
- **Note: Make certain that the bolt is fully engaged into the nutsert. Failure to do so can strip nutsert threads.**
- Tighten bolt completely until nutsert compresses onto sheet metal.
- Make certain that nutsert is fully compressed.
- Repeat at all four locations.



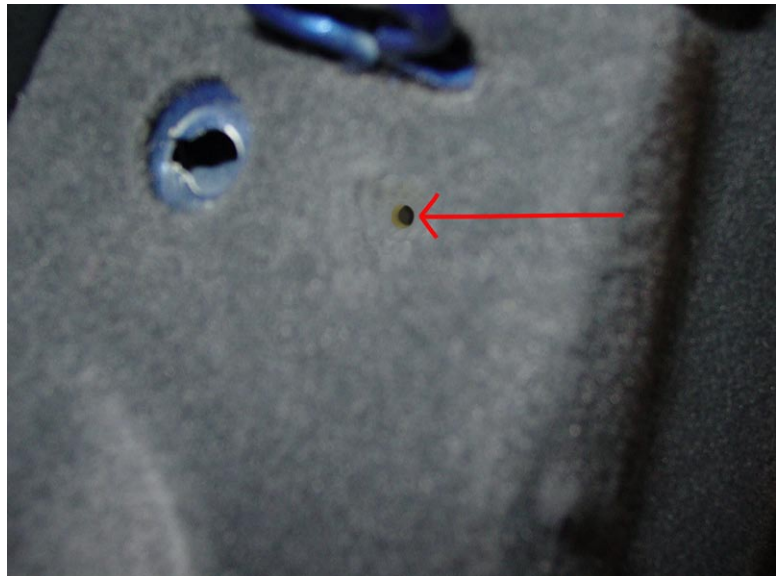
Step 17 — Scrape body filler at lower mounting points

- Note: Only if required. This step generally applies to R32 only.



Step 18 — Replace carpet and locate holes

- Refer to step 10 and replace carpet in its original position.
- Refer to steps 9, 8, 7, 6 and replace all removed components.
- Using awl, feel around carpet area for center of nutsert. Poke hole in the carpet. Repeat at all four locations.
- Using 1/4" drill bit gently ream out plastic carpet backing. **Note: Do not drill into nutsert. This is only for cleaning a finished hole in the carpet.**



Step 19 — Install Stressbrace

- Using four (4) M8 black oxide hex head fasteners, insert each fastener into the holes and tighten them uniformly until they begin to thread into the nutsert. Once they begin to thread evenly tighten all fasteners until they are tight and fully seated into the countersunk areas in the Stressbrace.
- Replace hatch carpet
- Refer to steps 5, 4, 3 and 2 to replace rear seat backs and bottoms.



Stressbrace with rear seats folded



Stressbrace with 1/2 rear seats folded from front



Stressbrace with 1/2 rear seats folded from rear

